

Blue ship March 17

Work Order ID 114475

\*114475\*

Page 1

March-06-14 11:38:52 AM

Item ID: D3413-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: O-Ring

Start Date: 3/06/14

Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 3/11/14

Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3413

Rev A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3413

Dwg Rev: A

Prog Rev: A

304.250" x 4.00"

2- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

6 0 Jm14-03-7

6 0 Jm14-03-7

# Work Order ID 114475

March-06-14 11:38:52 AM

**\*114475\***

Page 2

Item ID: D3413-1

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: O-Ring

Start Date: 3/06/14

Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 3/11/14

Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

155

0.00

**\*155\***

SprayPaint

Memo

0.00

Spray Painting

prime b 126022  
delfleet blue b 126437  
delfleet clear b 121703

165

QC14- Inspect Spray Paint

0.00

**\*165\***

QC

Memo

0.00

Quality Control



# Work Order ID 114475

March-06-14 11:38:52 AM

**\*114475\***

Page 3

Item ID: D3413-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: O-Ring

Start Date: 3/06/14

Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 3/11/14

Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*170\***

Packaging

Memo

ST446

0.00

Packaging

14/3/17

(6)

DAS  
32  
9-89

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

ML5 140377

ML4.0317



# Picklist Print

March-06-14 11:30:15 AM

Page 1

Work Order ID: 114475  
 Parent Item: D3413-1  
 Parent Item Name: O-Ring

Start Date: 3/06/14 Required Date: 3/11/14  
 Start Qty: 6.00 Required Qty: 6.00

Comments: IPP Rev:A05.09.13New issueKJ/JLM  
 IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000 304 BAR .250 x 4.00		Purchased	No			100	f	35.5000	0.25	2		JUN 03 7	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT051		35.5							
				123313		11.5							
				M128247		24			128247.				





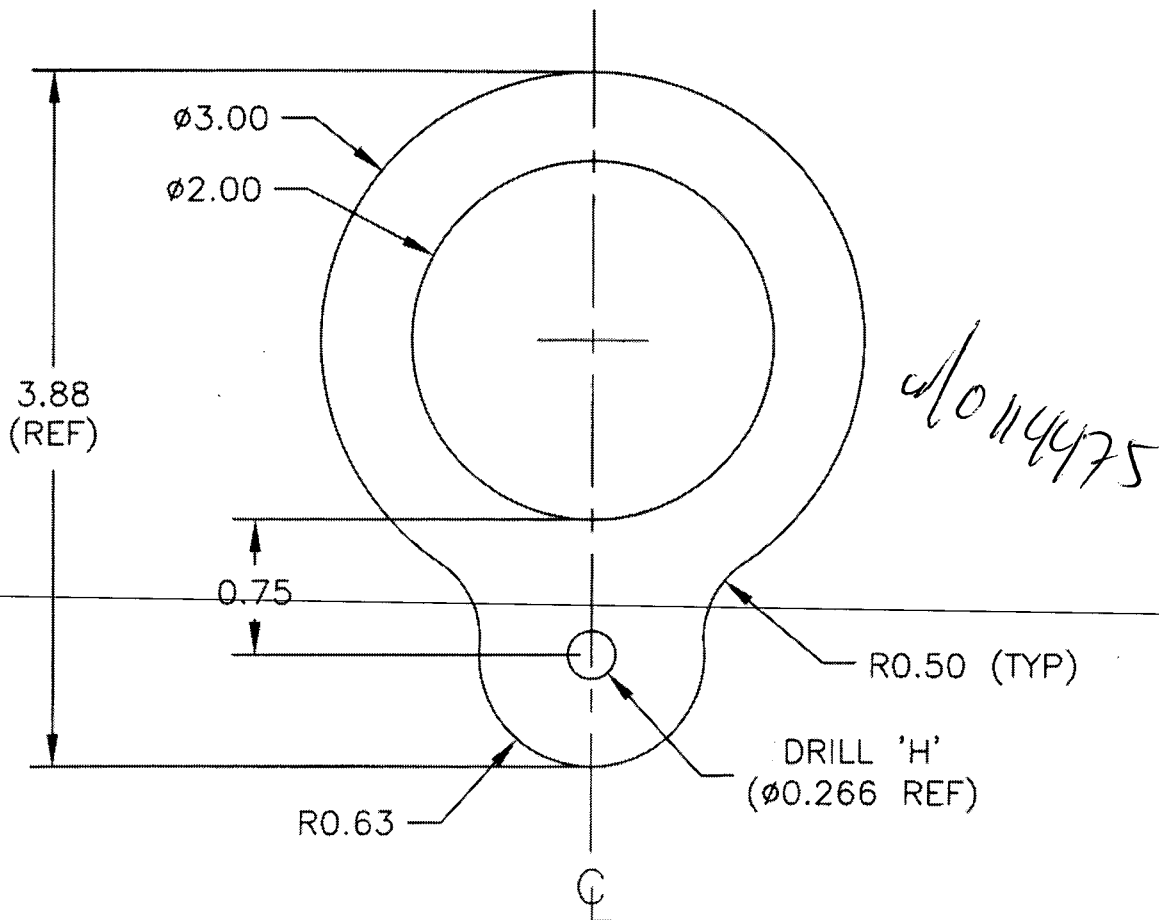






DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED  
05-09-06 *[Signature]*



### D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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